

Work Order ID 77735, 75207

\*77735\*

Page 1

Monday, December 19, 2011 12:38:40 PM

Item ID: D3199-4 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bracket, Fwd RH  
 Start Date: 12/19/2011 Start Qty: 44.00 \*44\* Cust Item ID:  
 Required Date: 12/23/2011 Req'd Qty: 44.00 \*44\* Customer:  
 Reference:

Approvals: Process Plan: UMF Date: 11-12-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3199	E

100 0.00

\*100\*

Waterjet  
 FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut as per Dwg D3199  
 Dwg Rev: \_\_\_\_\_  
 Prog Rev: \_\_\_\_\_

Deburr if required

110

\*110\*

QC  
 Quality Control

QC2- Inspect parts off machine FAI/FAIB 0.00

Memo

0.00

see w/o 75207 ATTACHED

*[Signature]*

*A UMF 11-12-19*

# Work Order ID 77735

Monday, December 19, 2011 12:38:40 PM

**\*77735\***

Page 2

Item ID: D3199-4 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket, Fwd RH  
 Start Date: 12/19/2011 Start Qty: 44.00 **\*44\*** Cust Item ID:  
 Required Date: 12/23/2011 Req'd Qty: 44.00 **\*44\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<del>N</del> A	<del>6</del>					
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg Small Fab  Memo	0.00  0.00	8	11/12/20		(43)			PTO on the W/O 75207-2
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	8	11/12/20		(43)			cont of

# Work Order ID 77735

**\*77735\***

Page 3

Monday, December 19, 2011 12:38:40 PM

Item ID: D3199-4 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Bracket, Fwd RH  
Start Date: 12/19/2011 Start Qty: 44.00 **\*44\*** Cust Item ID:  
Required Date: 12/23/2011 Req'd Qty: 44.00 **\*44\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<b>*150*</b>									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 11-30								
	OVEN TEMPERATURE: 320								
	FINISH TIME: 12-00								
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC									
Quality Control	Memo	0.00							
170	Identify as per dwg & Stock Location: 236B	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

43 X 9 M-L 11/12/21

43 BR 11-12-21

11/12/22 430

**Work Order ID 77735****\*77735\***

Page 4

Item ID: D3199-4

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket, Fwd RH

Stop **\*NS2\***

Start Date: 12/19/2011 Start Qty: 44.00

**\*44\***

Cust Item ID:

Required Date: 12/23/2011 Req'd Qty: 44.00

**\*44\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

11/12/23  
put in #75207  
mr (1-12-22)

# Picklist Print

Monday, December 19, 2011 12:38:40 PM

Page 1

Work Order ID: 77735

Parent Item: D3199-4

Parent Item Name: Bracket, Fwd RH

Start Date: 12/19/2011

Required Date: 12/23/2011

Start Qty: 44.00

Required Qty: 44.00

Comments: IPP RevA: RevC-prelim DD verified by:EC  
531 DD verf:EC

IPP Rev:B 11.03.31 as per ecn 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	257.5165	0.1673	7.7486316			

Location

MAT020

Loc Qty

257.5165

Loc Code

116623

0.2

117933

27.3442

118400

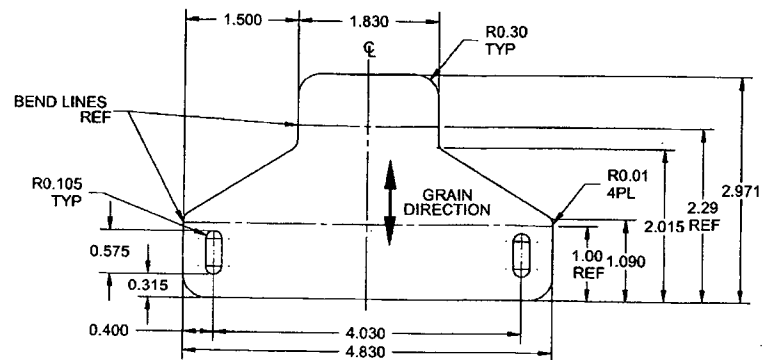
25.6723

118964

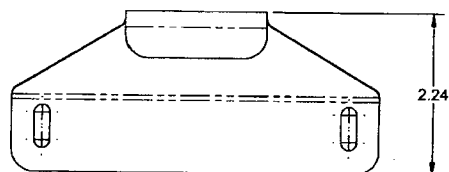
36.5

119346

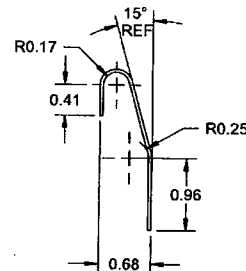
167.8



**D3199-1F FLAT PATTERN**



**D3199-1 BRACKET**  
MADE FROM D3199-1F

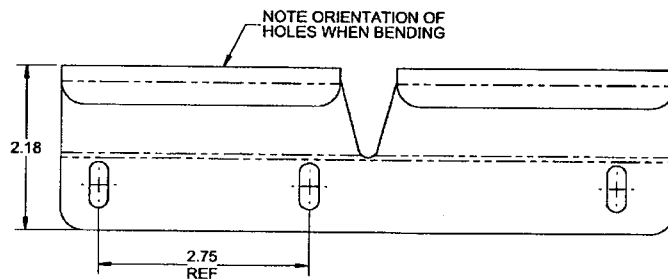


**NOTES:**

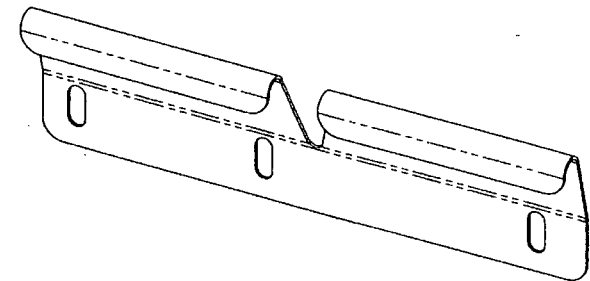
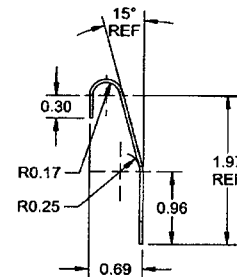
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

**RELEASED**  
2011-07-18  
MP

REV.	DESCRIPTION	BY	DATE
E	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PART11-78	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
DESIGN	DRAWN	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3199</b> TITLE <b>BRACKET</b> SCALE NTS COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.11		



**D3199-3 BRACKET**  
MADE FROM D3199-3F



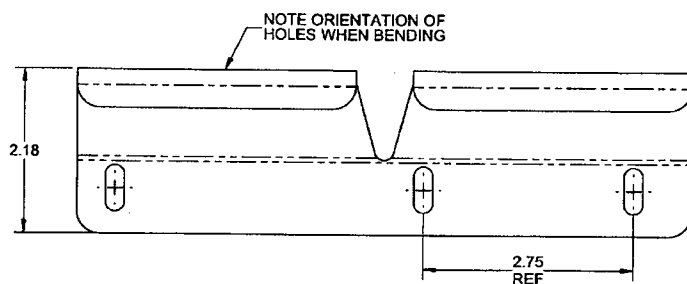
#77735

RELEASED

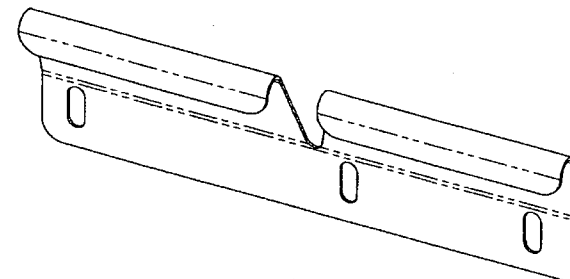
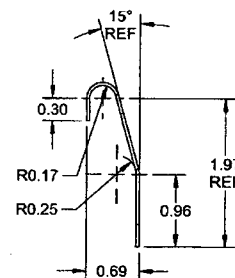
2011-07-18

WJD

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3199</b>	REV. E
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
DATE	<b>11.07.11</b>	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**D3199-4 BRACKET**  
MADE FROM D3199-3F



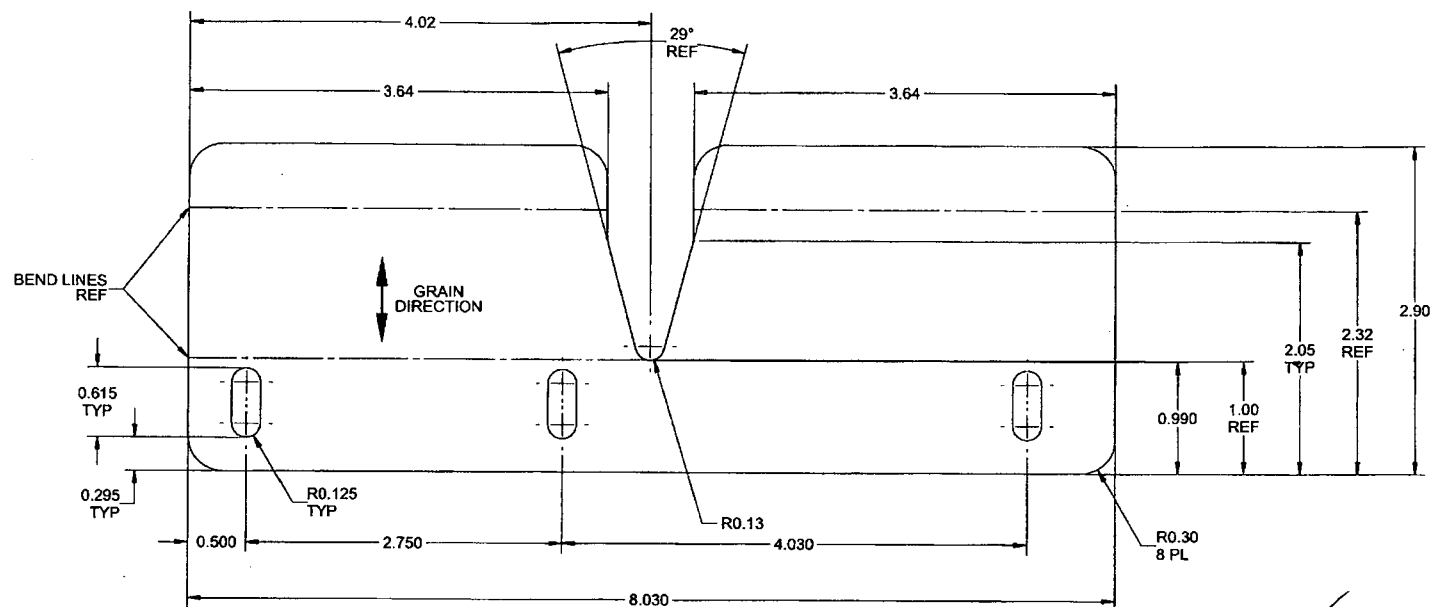
to 20

#77735

RELEASED  
2011-07-18  
JMS

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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**D3199-3F FLAT PATTERN**

*#77735*  
**RELEASED**  
 2011-07-18  
*WMD*

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH  
 PER MIL-S-5058, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
 REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.07.11	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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Work Order ID

75207-2

\*75207\*

Page 1

October-18-11 4:11:27 PM

Item ID: D3199-4

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Bracket, Fwd RH

Start Date: 18/10/2011 Start Qty: 90.00

\*90\*

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

\*90\*

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 11/10/11

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3199

E

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: E

Prog Rev: E

Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

B11-10-19

136

B11-10-19

Split

Need to slip

Oct. 24 \*

closed?

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75207

**\*75207\***

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October-18-11 4:11:27 PM

Item ID: D3199-4

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket. Fwd RH

Start Date: 18/10/2011 Start Qty: 90.00

**\*90\***

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

**\*90\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*Success 125*

*count*  
*(x136)*

*Aspelt*

130

Bend as per dwg  
Small Fab

0.00

**\*130\***

Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

QC

Memo

0.00

Quality Control

W/O:		75207 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-4 PAR #: \_\_\_\_\_ Fault Category: Small FAB NCR: Yes No DQA: OK Date: 12/01/03  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/01/03

NCR: <u>11-1088</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>5.13 x 3 =</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/12/19	120	3 pieces scrap when was cut on water jet R.L. Process miss during cutting	S 057017 11/12/19	Scrap dishes no repair	S 11/12/19	S 11/12/19	S 11/12/19 057012	S 11/12/19

NOTE: Date & initial all entries

**Work Order ID 75207****\*75207\***

Page 3

October-18-11 4:11:27 PM

Item ID: D3199-4

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket, Fwd RH

Start Date: 18/10/2011 Start Qty: 90.00

**\*90\***

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

**\*90\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

START TIME: \_\_\_\_\_  
OVEN TEMPERATURE: \_\_\_\_\_  
FINISH TIME: \_\_\_\_\_

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75207

**\*75207\***

Page 4

October-18-11 4:11:27 PM

Item ID: D3199-4

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Bracket. Fwd RH

Start Date: 18/10/2011 Start Qty: 90.00

**\*90\***

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 90.00

**\*90\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

*w/o already  
ccsted. Rabar on  
supply see new  
w/o  
77735*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

October-18-11 4:11:32 PM

Page 1

Work Order ID: 75207

\*75207\*

Parent Item: D3199-4

\*D3199-4\*

Parent Item Name: Bracket, Fwd RH

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 90.00

Required Qty: 90.00

Comments: IPP RevA: RevC-prelim DD verified by:EC  
11.03.31 as per ecn 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	137.0795	0.1673	15.84947	23.		

\*M304S20GA\*

304/316 .040 Sheet

\*\*

1811-10-18

Location

Loc Qty

Loc Code

MAT020

137.0795

116623

0.2

117550

8.363

117933

43.3442

118400

25.6723

118964

59.5

~~117933~~

118964

(136)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# FIRST ARTICLE INSPECTION CHECKLIST

DART AEROSPACE LTD		Work Order: 75207
Description: 38K451		Part Number: D3199-2
Inspection Dwg: D3199-2		Rev: 1
Page 1 of 1		

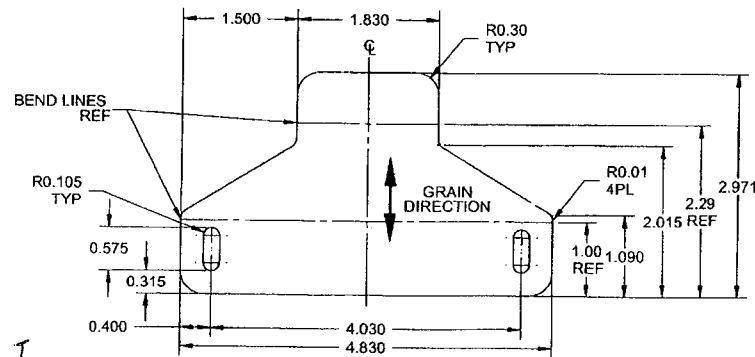
☒ First Article ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Dimension	Accept	Reject	Method of Inspection	Comments
3.04	4	±.30	3.640	✓			V	
4.02	4	±.30	4.002	✓			V	
2.90	4	±.30	2.904	✓			V	
9.90	4	±.30	1.003	✓			V	
6.18	4	±.30	6.18	✓			V	
2.95	4	±.30	2.99	✓			V	
1.500	4	±.30	5.01	✓			V	
2.755	4	±.30	2.754	✓			V	
4.030	4	±.30	4.032	✓			V	
8.030	4	±.30	8.038	✓			V	
0.40	4	±.30	0.44	✓			V	

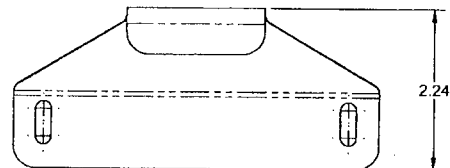
Measured by: 12	Date: 11-10-19	Audited by: S	Date: 11/10/19	Prototype Approval:	Date:
Rev: A	Date: Change	Revised by: KJ/LLM	Approved		

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO.

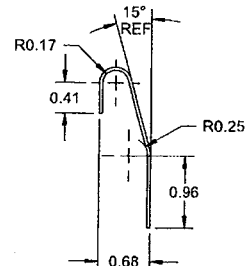
75207MLJ  
11/10/18



D3199-1F FLAT PATTERN



D3199-1 BRACKET  
MADE FROM D3199-1F



RELEASED  
2011-07-18

- NOTES:
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
  - 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

DESIGN	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
DRAWN	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF.: PART11-79	MB	11.03.21
CHECKED	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
MFG. APPR.	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
APPROVED	NEW ISSUE	CP	03.08.05
DE APPR.		BY	DATE
DATE	11.07.11		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3199  
REV. E  
SHEET 1 OF 4

TITLE BRACKET  
SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

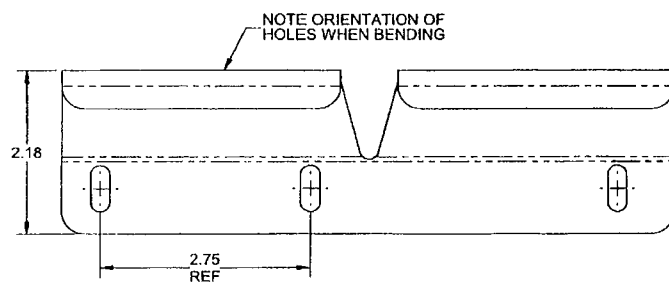
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

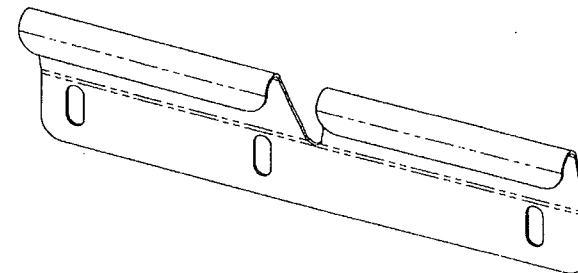
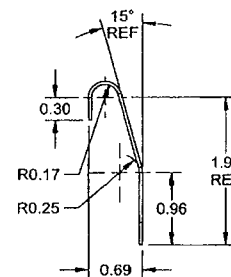
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

75207



**D3199-3 BRACKET**  
MADE FROM D3199-3F



RELEASED  
2011-07-18

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3199</b>	REV. E
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE <b>BRACKET</b>	SCALE
DE APPR.		NTS	
DATE	11.07.11	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

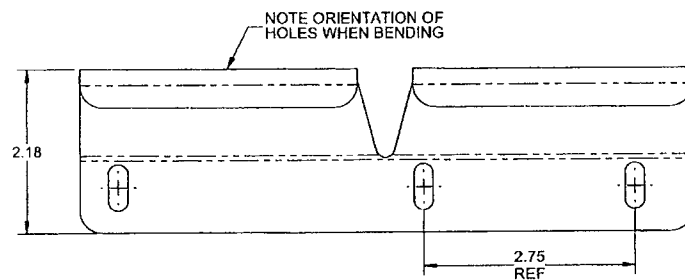
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

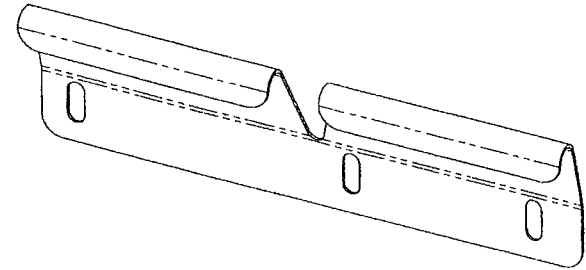
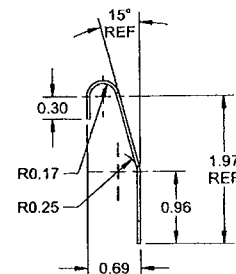
**NOTE:** Date & initial all entries



75207



**D3199-4 BRACKET**  
MADE FROM D3199-3F



RELEASED  
2011-07-18  
JMT

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

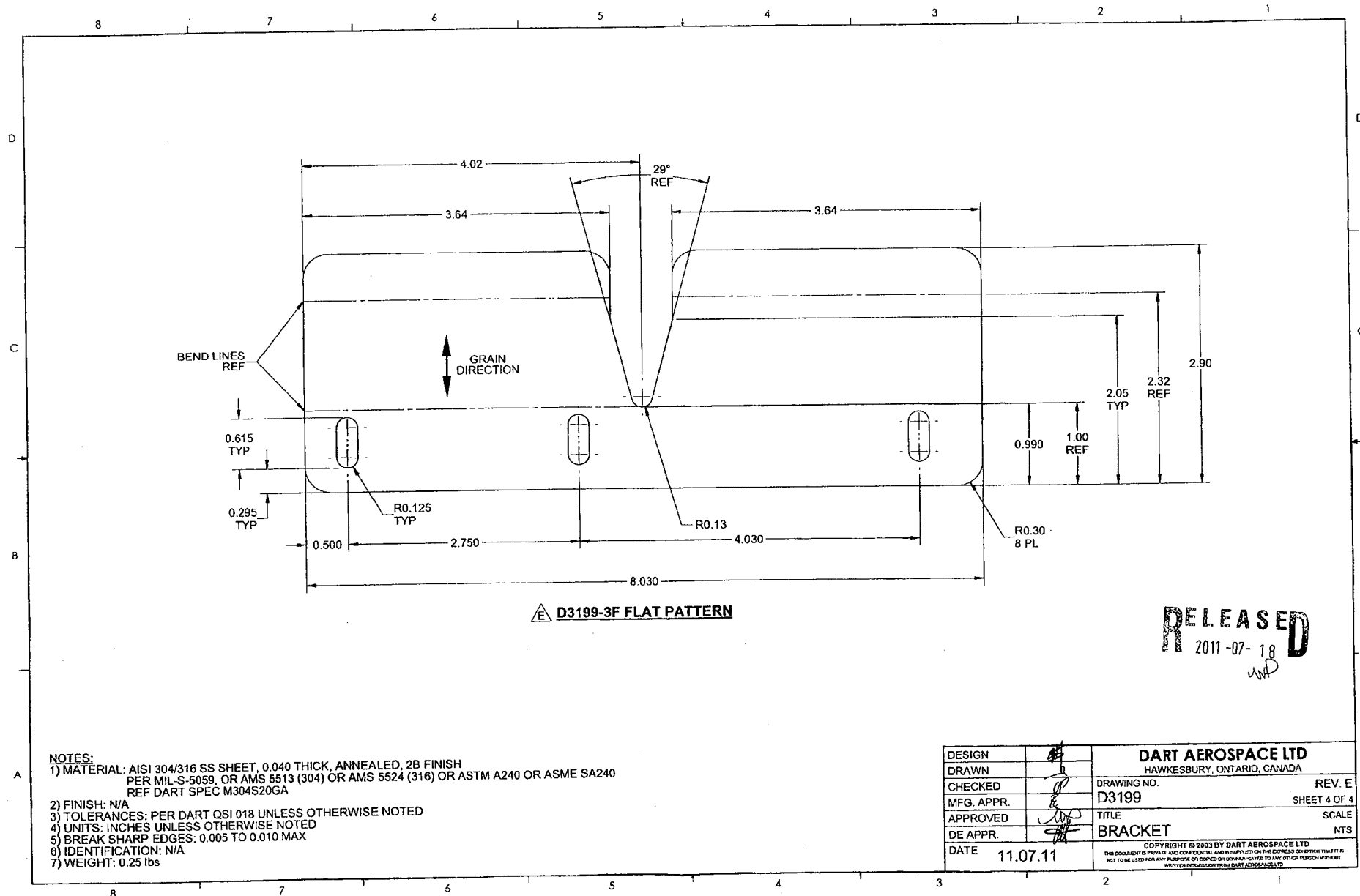
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

75207



**RELEASED**  
2011-07-18  
JNA

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH  
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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